Work Order ID 60299 Page 1 July 1, 2010 12:58:40 PM Accept Setup Start **DSK078** Item ID: **Revision ID:** Stop D2893-1 TURNING DETAIL **Item Name: Start Qty: 10.00** 01/07/2010 Cust Item ID: **Start Date: Required Date: 29/07/2010** Req'd Qty: 10.00 **Customer:** Reference: 10.07.01 Run Start Date: Tooling: Date: Approvals: Stop SPC (Y/N): Date: QC: Date: Reject Reject Insp. Set Up/ Tool ID Tool # Plan Accept Sequence ID/ Operation Qty Qty Number Stamp Code Description **Run Hours** Work Center ID **Draw Nbr Revision Nbr DSK078** Rev A 0.00 100 MORI SEIKI CNC LATHE LARGE 0.00 Doosan Memo Doosan Lathe Turn blank as per Folio FA081 10/04/23 (4TH AXIS PLUG DT8492) OC2- Inspect parts off machine FAI/FAIB 0.00 110 Memo 3/10/04/23 Quality Control 120 QC8- Inspect parts - second check

QC

Quality Control

Memo

Work Order ID 60299

July 1, 2010 12:58:40 PM



Page 2

Item ID:

DSK078

Accept

Setup Start



Revision ID:

Item Name:

D2893-1 TURNING DETAIL

Start Date:

01/07/2010

Start Qty: 10.00

Required Date: 29/07/2010

Req'd Qty: 10.00



Cust Item ID: **Customer:**

Reference:

Approvals:

Process Plan: ____

Date:

Date:

Tooling:

0.00

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool ID

18,0/07/05

Date:

Tool # Plan

Code

Reject

Qty

Stop



Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Packaging

Memo

Identify and Stock in Kanban Location: C. N. C

254078

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Run

Start



Stop

Reject Insp.

Number Stamp

Accept

Qty

10/07/. U 10.5426

Picklist Print

July 1, 2010 12:58:40 PM

Work Order ID: 60299

Parent Item: **DSK078**

Parent Item Name: D2893-1 TURNING DETAIL

Start Date: 01/07/2010

Required Date: 29/07/2010

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP rev A. 08.03.13 new issue EC

Component	Item	ID/
Item Name		

Replacement Mfg/ Item ID Purch Bin **Primary** Item Location

Last Location Route Seq ID

Unit of Qty on Measure Hand

Each

Qty per Kit Total

Qty

Date Issued

Status

Page 1

D6104-005

Round Billet, 17-4

Manufactured

No

0.0000

10

B 60387

5/10/04/23

Qty

Issued

DART AEROSPACE LTD	Work Order:	60299
Description: Turning Detail for D2893-1	Part Number:	DSK078
Inspection Dwg: DSK078 Rev: A		Page 1 of 1

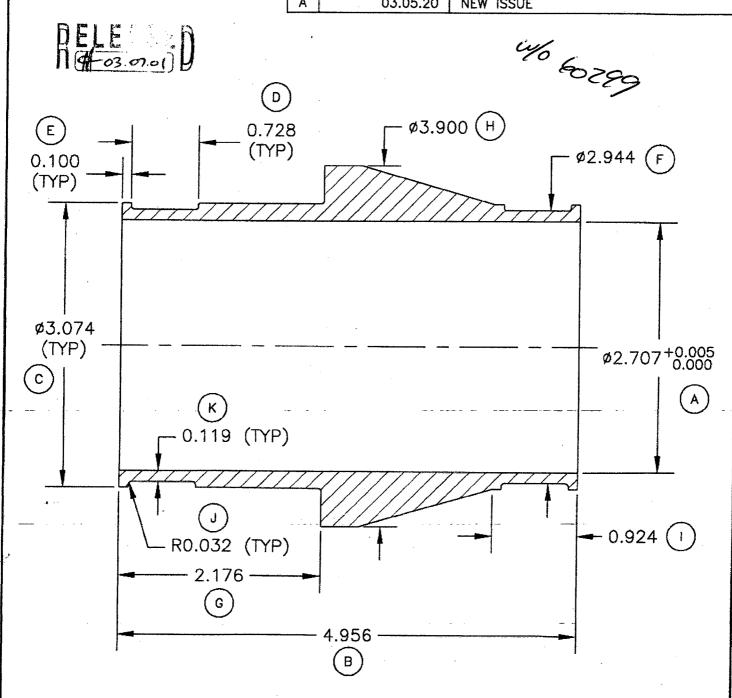
		FIRST	ARTICLE IN	SPECTION	DIMENSI	ON SHEE	Т	
			X First	Article	Proto	type		
					Record	Actual Dim	ensions	- · · ·
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
				Lathe Sectio	n			<u> </u>
Α	2.707	2.712		2,4085	12201	2.708	2,408	2.739
В	4.946	4.966		4.960	4.762	Y961	4.962	4.862
С	3.064	3.084		3025	3.0245	3025	3.075	2013
D	0.718	0.738		.725	129	729	129	125
E	0.090	0.110		.103	103	.103	1103	103
F	2.934	2.954		2.945	2.495	2,486	2.495	2845
G	2.166	2.186		2.183	2,177	2.144	2177	2011
Н	3.890	3.910		3.702	3, 782	3803	3.802	3,902
Į.	0.914	0.934		. 720	-920	-720	.120	370
J	0.022	0.042		.030	-030	650-	-070	.030
K	0.109	0.129		.120	12d	-120	.120	.121
L					,			
M								
N								
0								
Р								
	Measure	d by:				Date:	10/01	1/2.3
<u> </u>	measure	u by.	\			Date:	10,000	
	Audited by:					Date:		
Proto	type Appr	oval:				Date:		
Rev	1.0					Approved		
<u> </u>	08.04.22	New Issue				[KJ/	JLM O	411

DART AEROSPACE LTD	Work Order:	60299
Description: Turning Detail for D2893-1	Part Number:	DSK078
Inspection Dwg: DSK078 Rev: A		Page 1 of 1

Name		FIRST ARTICLE INSPECTION DIMENSION SHEET							
Dim Min Max Go/No Go Gauge A	•			X First A	\rticle [Proto	type		
Date: Prototype Approval: Revised by Approved Page Pa						Record	Actual Dime	ensions	
A 2.707 2.712 2.707	Dim	Min	Max	1	16	17	18	19	110
B					Lathe Sectio	n .	1		
B	А	2.707	2.712	T .	2409	2.407	1109	7.709	9 109
C 3.064 3.084 3.075 7.075 7.075 7.075 D			1		4.962	4962	4 8/2	4863	4962
E 0.090 0.110	С	3.064	3.084		3.075		3.075		1.035
F 2.934 2.954 2.545 2.545 2.745	D	0.718	0.738		-729	-129	129	125	-725
G 2.166 2.186 2.177	E	0.090	0.110		-103	-103	-103/	-103	-103
G 2.166 2.186 2.177	F	2.934	2.954		2.545	2945	2943	2245	2945
1	G	2.166	2.186			2111	2/177	2,117	2777
0.914 0.934 .720 .921 .720 .920 .921 .720 .920 .921 .920	Н	3.890	3.910		3.901	3,901	3 802	3.501	3702
K 0.109 0.129 ./20 .// ./20 ./	l	0.914	0.934		.720	, 820	-921		.820
K 0.109 0.129	ڶ	0.022	0.042		.03e	-030	-030	-030	OIO.
L M M M M M M M M M	K	0.109	0.129		. (20)	.//8			120
N O Date: 1004/22 Measured by: Date: Date: Prototype Approval: Date: Rev Date Change Revised by Approved	L								
O P Date: 1/Wc4/22 Audited by: Date: Date: Date: Prototype Approval: Date: Rev Date Change Revised by Approved	M								
P	N								
Measured by: Date: /Wot/22 Audited by: Date: Prototype Approval: Date: Rev Date Change Revised by Approved									
Audited by: Prototype Approval: Rev Date Change Revised by Approved	Р								
Audited by: Prototype Approval: Rev Date Change Revised by Approved				<u> </u>			_		
Prototype Approval: Date: Rev Date Change Revised by Approved		Measured by: SUS Date: /Wc7/22							
Rev Date Change Revised by Approved		Audited by:					Date:		
	Proto	Prototype Approval: Date:							
	Rev	Date (Change				Re	vised by	Approvedi
		·							all



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED	APPROVED #	DRAWING NO. DSK 078 SHEET	REV. A			
DATE		TITLE	SCALE			
03.05.20		TURNING DETAIL FOR D2893-1	1:1			
Δ	03.05.20	NEW ISSUE				



D2893-1 TURNING DETAIL

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